

Work Order ID 86784

86784

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July-06 2:47:54 PM

Item ID: D2975

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 7/06/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(12)			
D2975	Rev A								

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2975 Dwg Rev: A Prog Rev: A 2-

100 -063

Deburr if necessary

12-7-19

110

QC2- Inspect parts off machine FAI/FATB

0.00

110

QC

Memo

0.00

Quality Control

12-7-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SMB
12-7-20

DAS
16
8-8

12/6/20

(12)

(0)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start *NS1*

Stop *NS2*

8

8

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form as per dwg D2975 using DT8261 & DT8326

140

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

QC

Quality Control

150

0.00

Large Fab

0.00

Large Fab

Memo

Large Fab

Weld hard surface using DT8210 as per Dwg D2975 & QSI 004Qty

Description

Batch A/R 7560 Hardcoat Rod

m/22359 → 228

Dart Aerospace Ltd

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Item ID: D2975 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearshoe
Start Date: 7/06/12 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 8/10/12 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(12)			
170 *170* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 2:30 FINISH TIME: 3:00 OVEN TEMPERATURE:	0.00 0.00				12x0			m/f 12/08/14
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12x			11/08/14

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>500</u>	0.00	<u>SL</u>						
190									
Packaging	Memo	0.00							
Packaging									
200	QC21 - Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MLJ 12/08/17
12-08-16

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Picklist Print

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Page 1

Work Order ID: 86784

Parent Item: D2975

Parent Item Name: Wearshoe

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C02.10.23Re-formatKJ
IPP Rev:D Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 1010/1025 sheet 16GA		Purchased	No			100	sf	48.6600	0.2758	2.3225263			

B-12-7-19

Location	Loc Qty	Loc Code
MAT019	48.66	
116791	15.07	
117500	16.02	
121195	17.57	

~~122455~~
122458

(12)

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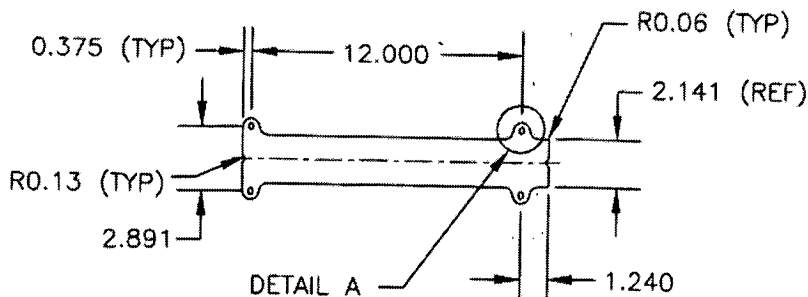
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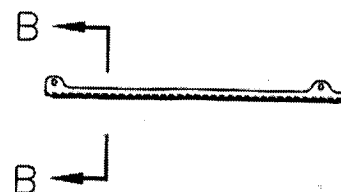


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

FLAT PATTERN



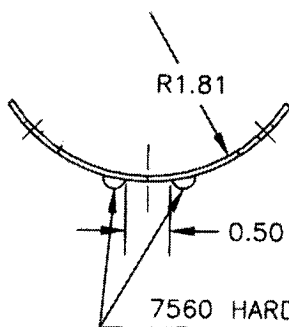
BENDING DETAIL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86789

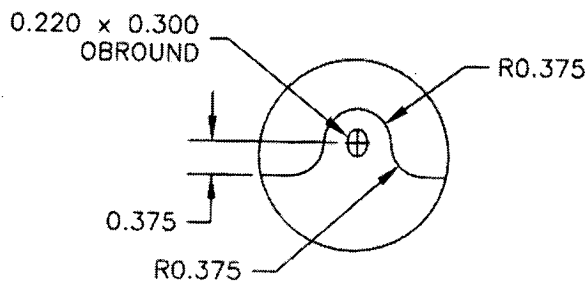
PL 12-079

SECTION B-B SCALE 2:5



7560 HARDCOAT WELDS TO
WITHIN 0.25 OF WEARSHOE
ENDS 0.063 TO 0.125 THICK

DETAIL A SCALE 2:5



RELEASED
00.05.11 *[Signature]*

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
16 GAUGE (0.063 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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